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1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

D119-796-141  
Job Sheet 194132



Part No: D119-796-141

Job Qty: 1 pcs

Part Name: Fwd Crosstube Installation Without Step (No Hardware)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/25/19

Job Tracking No:

Due Date: 5/3/19 *June 3*

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DRWG D119-796-141 REV.H IPP REV:C 14.11.19 AS PER REV.C DD VERF:JLM IPP REV:D 14.12.12 AS  
PER REV.pd1 DD VERF:JLM IPP REV:E 15.02.11 AS PER REV F JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

| Op<br>No | Operation             | Qty   | Start Date | Due<br>Date | Standard     |            | Workcenter/Supplier   |           | Sign-off              |
|----------|-----------------------|-------|------------|-------------|--------------|------------|-----------------------|-----------|-----------------------|
|          |                       |       |            |             | Setup<br>Hrs | Run<br>Hrs | Workcenter / Supplier | Lead Time |                       |
| 130      | Crosstubes - Bend - 1 | 1 pcs | 5/3/19     | 5/3/19      | 0.00         | 3.85       | Crosstubes - Bend     |           | <i>GP/BB 7/3/2019</i> |
| 140      | QC 15                 | 1 pcs | 5/3/19     | 5/3/19      | 0.00         | 0.00       | QC 15 - 12            |           |                       |
|          |                       |       |            |             |              |            | QC 15 - 3             |           |                       |
|          |                       |       |            |             |              |            | QC 15 - 47            |           | <i>TV</i>             |
|          |                       |       |            |             |              |            | QC 15 - 49            |           |                       |
|          |                       |       |            |             |              |            | QC 15 - 58            |           |                       |
|          |                       |       |            |             |              |            | QC 15 - 9             |           |                       |
|          |                       |       |            |             |              |            | QC 15 - 68            |           |                       |
| 145      | Crosstubes - 2 - B4B  | 1 pcs | 5/3/19     | 5/3/19      | 0.00         | 3.06       | Crosstubes - 1 - B4B  |           |                       |
|          |                       |       |            |             |              |            | Crosstubes - 2 - B4B  |           | <i>GP/BB 19-07-08</i> |
|          |                       |       |            |             |              |            | Crosstubes - 3 - B4B  |           |                       |
|          |                       |       |            |             |              |            | Crosstubes - 4 - B4B  |           |                       |
| 150      | Crosstubes - 3 - B4B  | 1 pcs | 5/3/19     | 5/3/19      | 0.00         | 3.06       | Crosstubes - 1 - B4B  |           |                       |
|          |                       |       |            |             |              |            | Crosstubes - 2 - B4B  |           | <i>GP 19-07-09</i>    |
|          |                       |       |            |             |              |            | Crosstubes - 3 - B4B  |           |                       |
|          |                       |       |            |             |              |            | Crosstubes - 4 - B4B  |           |                       |
| 160      | Crosstubes - 4 - B4B  | 1 pcs | 5/3/19     | 5/3/19      | 0.00         | 1.49       | Crosstubes - 1 - B4B  |           |                       |
|          |                       |       |            |             |              |            | Crosstubes - 2 - B4B  |           |                       |
|          |                       |       |            |             |              |            | Crosstubes - 3 - B4B  |           |                       |
|          |                       |       |            |             |              |            | Crosstubes - 4 - B4B  |           |                       |
| 175      | QC 7                  | 1 pcs | 5/3/19     | 5/3/19      | 0.00         | 0.00       | QC 7 - 10             |           |                       |
|          |                       |       |            |             |              |            | QC 7 - 13             |           |                       |
|          |                       |       |            |             |              |            | QC 7 - 14             |           |                       |
|          |                       |       |            |             |              |            | QC 7 - 15             |           |                       |
|          |                       |       |            |             |              |            | QC 7 - 17             |           |                       |
|          |                       |       |            |             |              |            | QC 7 - 18             |           |                       |
|          |                       |       |            |             |              |            | QC 7 - 19             |           |                       |
|          |                       |       |            |             |              |            | QC 7 - 2              |           |                       |
|          |                       |       |            |             |              |            | QC 7 - 28             |           |                       |
|          |                       |       |            |             |              |            | QC 7 - 3              |           |                       |

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|                                          |        |           |  |                        |                                          |
|------------------------------------------|--------|-----------|--|------------------------|------------------------------------------|
|                                          |        |           |  | QC 7 - 30              |                                          |
|                                          |        |           |  | QC 7 - 34              |                                          |
|                                          |        |           |  | QC 7 - 36              |                                          |
|                                          |        |           |  | QC 7 - 37              |                                          |
|                                          |        |           |  | QC 7 - 41              |                                          |
|                                          |        |           |  | QC 7 - 47              |                                          |
|                                          |        |           |  | QC 7 - 48              |                                          |
|                                          |        |           |  | QC 7 - 51              |                                          |
|                                          |        |           |  | QC 7 - 58              |                                          |
|                                          |        |           |  | QC 7 - 59              |                                          |
|                                          |        |           |  | QC 7 - 60              |                                          |
|                                          |        |           |  | QC 7 - 9               |                                          |
|                                          |        |           |  | QC 7 - 68              |                                          |
|                                          |        |           |  | QC 7 - 50              |                                          |
|                                          |        |           |  | QC 7 - 67              |                                          |
|                                          |        |           |  | QC 7 - 40              |                                          |
| 180 Outsource - 2 - NDT per QSI038 1 pcs | 5/3/19 |           |  | SKY002-VC 2            | DAS<br>AUG 01 2019 40<br>14209-08-87     |
| 190 Packaging 2-1 - Receive - B4B 1 pcs  | 5/3/19 | 0.00 0.00 |  | Packaging 2 - 1 - B4B  |                                          |
|                                          |        |           |  | Packaging 2 - 2 - B4B  |                                          |
|                                          |        |           |  | Packaging 2 - 3 - B4B  |                                          |
|                                          |        |           |  | Packaging 2 - 5 - B4B  |                                          |
|                                          |        |           |  | Packaging 2 - 4 - B4B  |                                          |
|                                          |        |           |  | Packaging 2 - 6 - B4B  |                                          |
|                                          |        |           |  | Packaging 2 - 7 - B4B  |                                          |
|                                          |        |           |  | Packaging 2 - 8 - B4B  |                                          |
|                                          |        |           |  | Packaging 2 - 9 - B4B  |                                          |
|                                          |        |           |  | Packaging 2 - 10 - B4B |                                          |
|                                          |        |           |  | Packaging 2 - 11 - B4B |                                          |
|                                          |        |           |  | Packaging 2 - 12 - B4B |                                          |
|                                          |        |           |  | Packaging 2 - 13 - B4B |                                          |
|                                          |        |           |  | Packaging 2 - 14 - B4B |                                          |
|                                          |        |           |  | Packaging 2 - 15 - B4B |                                          |
|                                          |        |           |  | Packaging 2 - 16 - B4B |                                          |
|                                          |        |           |  | Packaging 2 - 17 - B4B |                                          |
|                                          |        |           |  | Packaging 2 - 18 - B4B |                                          |
|                                          |        |           |  | Packaging 2 - 19 - B4B |                                          |
|                                          |        |           |  | Packaging 2 - 20 - B4B |                                          |
|                                          |        |           |  | Packaging 2 - 21 - B4B |                                          |
|                                          |        |           |  | Packaging 2 - 22 - B4B |                                          |
|                                          |        |           |  | Packaging 2 - 23 - B4B |                                          |
|                                          |        |           |  | Packaging 2 - 24 - B4B |                                          |
|                                          |        |           |  | Packaging 2 - 25 - B4B |                                          |
|                                          |        |           |  | Packaging 2 - 26 - B4B |                                          |
|                                          |        |           |  | Packaging 2 - 27 - B4B |                                          |
|                                          |        |           |  | Packaging 2 - 28 - B4B |                                          |
|                                          |        |           |  | Packaging 2 - 29 - B4B |                                          |
|                                          |        |           |  | Packaging 2 - 30 - B4B |                                          |
|                                          |        |           |  | Packaging 2 - 31 - B4B |                                          |
|                                          |        |           |  | Packaging 2 - 32 - B4B |                                          |
|                                          |        |           |  | Packaging 2 - 33 - B4B |                                          |
|                                          |        |           |  | Packaging 2 - 34 - B4B |                                          |
|                                          |        |           |  | Packaging 2 - 35 - B4B |                                          |
|                                          |        |           |  | Packaging 2 - 36 - B4B |                                          |
| 200 QC 6 1 pcs                           | 5/3/19 | 0.00 0.00 |  | QC 6 - 9               |                                          |
|                                          |        |           |  | QC 6 - 68              |                                          |
|                                          |        |           |  | QC 6 - 61              |                                          |
|                                          |        |           |  | QC 6 - 40              |                                          |
| 230 Spray Paint - 2 - B4B 1 pcs          | 5/3/19 | 0.00 1.36 |  | Spray Paint - 1 - B4B  | DAS<br>AUG 02 2019 40<br>AR 19-8-10 9-89 |
|                                          |        |           |  | Spray Paint - 2 - B4B  |                                          |

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|                           |       |        |           |                       |                    |
|---------------------------|-------|--------|-----------|-----------------------|--------------------|
|                           |       |        |           | Spray Paint - 3 - B4B |                    |
|                           |       |        |           | Spray Paint - 4 - B4B |                    |
| 240 QC 14                 | 1 pcs | 5/3/19 | 0.00 0.00 | QC 14 - 15            |                    |
|                           |       |        |           | QC 14 - 2             |                    |
|                           |       |        |           | QC 14 - 34            |                    |
|                           |       |        |           | QC 14 - 41            |                    |
|                           |       |        |           | QC 14 - 51            |                    |
|                           |       |        |           | QC 14 - 58            |                    |
|                           |       |        |           | QC 14 - 59            |                    |
|                           |       |        |           | QC 14 - 9             |                    |
|                           |       |        |           | QC 14 - 68            |                    |
|                           |       |        |           | QC 14 - 40            | AUG 12 2019 DAS 40 |
|                           |       |        |           | QC 14 - 19            | 9-89               |
|                           |       |        |           |                       |                    |
| 242 Crosstubes - 5 - B4B  | 1 pcs | 5/3/19 | 0.00 3.06 | Crosstubes - 1 - B4B  |                    |
|                           |       |        |           | Crosstubes - 2 - B4B  |                    |
|                           |       |        |           | Crosstubes - 3 - B4B  |                    |
|                           |       |        |           | Crosstubes - 4 - B4B  | AL 19-8-13         |
| 244 QC 5                  | 1 pcs | 5/3/19 | 0.00 0.00 | QC 5 - 10             |                    |
|                           |       |        |           | QC 5 - 12             |                    |
|                           |       |        |           | QC 5 - 17             |                    |
|                           |       |        |           | QC 5 - 18             |                    |
|                           |       |        |           | QC 5 - 19             |                    |
|                           |       |        |           | QC 5 - 22             |                    |
|                           |       |        |           | QC 5 - 24             |                    |
|                           |       |        |           | QC 5 - 3              |                    |
|                           |       |        |           | QC 5 - 43             |                    |
|                           |       |        |           | QC 5 - 49             |                    |
|                           |       |        |           | QC 5 - 51             |                    |
|                           |       |        |           | QC 5 - 58             |                    |
|                           |       |        |           | QC 5 - 68             | AUG 16 2019 DAS 68 |
|                           |       |        |           | QC 5 - 9              | 9-89               |
|                           |       |        |           | QC 5 - 50             |                    |
|                           |       |        |           | QC 5 - 30             |                    |
| 246 Spray Paint - 3 - B4B | 1 pcs | 5/3/19 | 0.00 1.36 | Spray Paint - 1 - B4B | AL 19-8-21         |
|                           |       |        |           | Spray Paint - 2 - B4B |                    |
|                           |       |        |           | Spray Paint - 3 - B4B |                    |
|                           |       |        |           | Spray Paint - 4 - B4B |                    |
| 248 Spray Paint - 4 - B4B | 1 pcs | 5/3/19 | 0.00 1.36 | Spray Paint - 1 - B4B |                    |
|                           |       |        |           | Spray Paint - 2 - B4B | AL 19-8-22         |
|                           |       |        |           | Spray Paint - 3 - B4B |                    |
|                           |       |        |           | Spray Paint - 4 - B4B |                    |
| 250 QC 14                 | 1 pcs | 5/3/19 | 0.00 0.00 | QC 14 - 15            |                    |
|                           |       |        |           | QC 14 - 2             |                    |
|                           |       |        |           | QC 14 - 34            |                    |
|                           |       |        |           | QC 14 - 41            |                    |
|                           |       |        |           | QC 14 - 51            |                    |
|                           |       |        |           | QC 14 - 58            |                    |
|                           |       |        |           | QC 14 - 59            |                    |
|                           |       |        |           | QC 14 - 9             |                    |
|                           |       |        |           | QC 14 - 68            | AUG 23 2019 DAS 68 |
|                           |       |        |           | QC 14 - 40            | 9-89               |
| 252 Crosstubes - 6 - B4B  | 1 pcs | 5/3/19 | 0.00 3.06 | Crosstubes - 1 - B4B  |                    |
|                           |       |        |           | Crosstubes - 2 - B4B  |                    |
|                           |       |        |           | Crosstubes - 3 - B4B  |                    |
|                           |       |        |           | Crosstubes - 4 - B4B  | AL 19-8-25         |
| 260 QC 5                  | 1 pcs | 5/3/19 | 0.00 0.00 | QC 5 - 10             |                    |
|                           |       |        |           | QC 5 - 12             |                    |

|                                                                                                                    |       |        |           |                        |                |
|--------------------------------------------------------------------------------------------------------------------|-------|--------|-----------|------------------------|----------------|
|                                                                                                                    |       |        |           | QC 5 - 17              |                |
|                                                                                                                    |       |        |           | QC 5 - 18              |                |
|                                                                                                                    |       |        |           | QC 5 - 19              |                |
|                                                                                                                    |       |        |           | QC 5 - 22              |                |
|                                                                                                                    |       |        |           | QC 5 - 24              |                |
|                                                                                                                    |       |        |           | QC 5 - 3               |                |
|                                                                                                                    |       |        |           | QC 5 - 43              |                |
|                                                                                                                    |       |        |           | QC 5 - 49              |                |
|                                                                                                                    |       |        |           | QC 5 - 51              |                |
|                                                                                                                    |       |        |           | QC 5 - 58              | DAS            |
|                                                                                                                    |       |        |           | QC 5 - 68              | AUG 26 2019 68 |
|                                                                                                                    |       |        |           | QC 5 - 9               | 9-89           |
|                                                                                                                    |       |        |           | QC 5 - 50              |                |
|                                                                                                                    |       |        |           | QC 5 - 30              |                |
|                                                                                                                    |       |        |           | QC 5 - 40              |                |
| 275 DC - 1 - B4B                                                                                                   | 1 pcs | 5/3/19 | 0.00 0.00 | DC - 1 - B4B           | NR             |
|                                                                                                                    |       |        |           | DC - 2 - B4B           |                |
| 290 Packaging 3-1 - Stock - B4B                                                                                    | 1 pcs | 5/3/19 | 0.00 0.00 | Packaging 3 - 1 - B4B  |                |
|                                                                                                                    |       |        |           | Packaging 3 - 2 - B4B  |                |
|                                                                                                                    |       |        |           | Packaging 3 - 3 - B4B  |                |
|                                                                                                                    |       |        |           | Packaging 3 - 4 - B4B  |                |
|                                                                                                                    |       |        |           | Packaging 3 - 5 - B4B  |                |
|                                                                                                                    |       |        |           | Packaging 3 - 6 - B4B  |                |
|                                                                                                                    |       |        |           | Packaging 3 - 7 - B4B  |                |
|                                                                                                                    |       |        |           | Packaging 3 - 8 - B4B  |                |
|                                                                                                                    |       |        |           | Packaging 3 - 9 - B4B  |                |
|                                                                                                                    |       |        |           | Packaging 3 - 10 - B4B |                |
|                                                                                                                    |       |        |           | Packaging 3 - 11 - B4B |                |
|                                                                                                                    |       |        |           | Packaging 3 - 12 - B4B |                |
|                                                                                                                    |       |        |           | Packaging 3 - 13 - B4B |                |
|                                                                                                                    |       |        |           | Packaging 3 - 14 - B4B |                |
|                                                                                                                    |       |        |           | Packaging 3 - 15 - B4B |                |
|                                                                                                                    |       |        |           | Packaging 3 - 16 - B4B |                |
|                                                                                                                    |       |        |           | Packaging 3 - 17 - B4B |                |
|                                                                                                                    |       |        |           | Packaging 3 - 18 - B4B |                |
|                                                                                                                    |       |        |           | Packaging 3 - 19 - B4B |                |
|                                                                                                                    |       |        |           | Packaging 3 - 20 - B4B |                |
|                                                                                                                    |       |        |           | Packaging 3 - 21 - B4B |                |
|                                                                                                                    |       |        |           | Packaging 3 - 22 - B4B | AL 19-8-26     |
|                                                                                                                    |       |        |           | Packaging 3 - 23 - B4B |                |
|                                                                                                                    |       |        |           | Packaging 3 - 24 - B4B |                |
|                                                                                                                    |       |        |           | Packaging 3 - 25 - B4B |                |
|                                                                                                                    |       |        |           | Packaging 3 - 26 - B4B |                |
|                                                                                                                    |       |        |           | Packaging 3 - 27 - B4B |                |
|                                                                                                                    |       |        |           | Packaging 3 - 28 - B4B |                |
|                                                                                                                    |       |        |           | Packaging 3 - 29 - B4B |                |
|                                                                                                                    |       |        |           | Packaging 3 - 30 - B4B |                |
|                                                                                                                    |       |        |           | Packaging 3 - 31 - B4B |                |
|                                                                                                                    |       |        |           | Packaging 3 - 32 - B4B |                |
|                                                                                                                    |       |        |           | Packaging 3 - 33 - B4B |                |
|                                                                                                                    |       |        |           | Packaging 3 - 34 - B4B |                |
|                                                                                                                    |       |        |           | Packaging 3 - 35 - B4B |                |
|                                                                                                                    |       |        |           | Packaging 3 - 36 - B4B |                |
| 300 QC 21 - FG                                                                                                     | 1 pcs | 5/3/19 | 0.00 0.00 | QC 21 - FG - 21        | DAS            |
|                                                                                                                    |       |        |           | QC 21 - FG - 70        | 70 AUG 26 2019 |
|                                                                                                                    |       |        |           | QC 21 - SA - 53        | 9-89           |
| Part Op 130 - CNC Bend Crosstube (CNC Alpha 160 Bender) Bend tube as per Dwg D119-796-141 using CNC bender program |       |        |           |                        |                |
| Descriptions: 140 - QC15 (QC15- Crosstube Dimensional Check)                                                       |       |        |           |                        |                |
| 145 - Crosstubes-1 (Crosstubes) 1- CUT TUBE AT HEIGHT ON FAI SHEET 2- VERFY HEIGHT: _____ BY QC15                  |       |        |           |                        |                |

LEVEL INSPECTOR: 3- DEBURR CUT SURFACE  
150 - \*\*\*\*\* ENSURE PROPER JIG POSITIONING \*\*\*\*\* ENSURE PROPER JIG POSITIONING  
\*\*\*\*\* 1-DRILL TUBE AS PER DWG USING DT 2- DRILL RIVET HOLES USING DT8787 FWD 3-  
DEBURR AND C'SINK RIVET HOLES AS PER DWG 4- FLIP TUBE, REPEAT STEP 2 AND 3 5- SCRIBE PART# AND  
BATCH# USING VIBRATING STYLUS ON INSIDE OF CUFF AS PER DWG D119-796-141 6- INSPECT AND REMOVE  
ALL MARKS FROM TUBE WITHIN LIMITS ON DWG D119-796-141  
160 - HandFinish5 (Crosstubes Chemical Conversion) \*\*\*IMMEDIATELY AFTER GRINDING\*\*\* 1- handfinish X-TUBE  
INSIDE AND OUT 2- ALODINE AND ACID ETCH X-TUBE INSIDE AND OUT AS PER QSI005.  
175 - QC7-1 (QC7-Inspect Chemical Conversion Coat)  
180 - Outsource2 (Outsource process - NDT per QSI038 4.1) \*\*\* WEAR LATEX GLOVES WHEN HANDLING  
CROSSTUBE\*\*\* Liquid Penetrant Inspection as per QSI 038Or Issue P/O: LPI as per ASTM 1417 Level 2  
Attach copy of NDT results to work order  
190 - Packaging2 (Receive & Inspect for Damage & Mat'l Certs) ReceiveEnsure copy of NDT results attached to work  
order.  
200 - QC6 (QC6- All purchased or subcontracted products) \*\*\* WEAR LATEX GLOVES WHEN HANDLING  
CROSSTUBE\*\*\* Inspect for damage & ensure results are as per Dwg D119-796-141  
230 - Spray Paint (Spray Paint / NDT Room) \*\*\*VERIFY BY BATCH # TO MATCH W/O  
\*\*\*VERIFY BY PART # TO MATCH W/O \*\*\*MASK SCRIBE  
B# & P# AND VERIFY\*\*\* 1- Prime Inside of tube. 2- Install nut plates as per dwg (D2873-043) 3- Mask cuffs per note#2.  
4- Prime exterior of tube per QSI005. Primer Batch: 5187203 Start Time: Finish Time:  
240 - QC14 (QC14- Inspect Spray Paint) \*\*\*VERIFY BY BATCH # TO MATCH W/O  
242 - Crosstubes-1 (Crosstubes) Assemble as per dwg D119-796-141 and Qsi 015 1- Abrade mating surfaces with  
Scotch Brite 7447 and clean with Dupont 4105s or equivalent as per dwg. 2- Install D5152-041 with proseal 890 on  
concave surface, 0.100" MIN thick as per dwg using DT10089 (identified righ and left) \*\*\*\*\*MAINTAIN CLAMPING  
PRESSURE ON FOR MIN 72HRS\*\*\*\*\* Proseal Batch: 5176610 EXP: 19/10 PROSEAL CURE  
TIME 72 HOURS: Start: 19-8-13 Finish: 19-8-16 3- Install support and shim using  
proseal 890 per dwg and clamp in position.  
244 - QC5 (QC5- Inspect part completeness to step on W/O)\*\*\*VERIFY BY BATCH # TO MATCH W/O  
246 - Spray Paint (Spray Paint / NDT Room) \*\*\*VERIFY BY BATCH # TO MATCH W/O  
1- Remove all non-fixed hardware and clean any excess proseal. 2- Scuff tube with Scotch Brite  
7447. 3- Mask cuff per note#2. 4- Prime as per dwg and QSI005 5- Apply matte clear as per dwg and QSI005 Clear  
Batch: 5184743 Primer 5189223  
248 - Spray Paint (Spray Paint / NDT Room) \*\*\*VERIFY BY BATCH # TO MATCH W/O  
1- Mask underside of tube as per dwg. Mask cuff per note#2. 2- Scuff tube with Scotch Brite 7447  
3- Paint outside of crosstube Paint Batch: 5201428  
250 - QC14 (QC14- Inspect Spray Paint) \*\*\*VERIFY BY BATCH # TO MATCH W/O  
252 - Crosstubes-1 (Crosstubes) 1- Re-install non fixed hardware per dwg \*\*\*Torque all clamps to 80-100 IN-LBS.\*\*\* 2-  
Apply a filet-seal of proseal 890 around supports. Allow proseal to dry before inspecting. Proseal 890  
Batch: 5176610 EXP: 19/10 PROSEAL CURE TIME 72 HOURS:  
Start: 19-8-23 Finish: 19-8-26  
260 - QC5 (QC5- Inspect part completeness to step on W/O) \*\*\*RE-CHECK TORCQUE ON CLAMP AFTER PROSEAL  
HAS CURED AS PER DWG.\*\*\* \*\*\*VERIFY BY BATCH # TO MATCH W/O  
275 - DC (Document Control) Photocopy bluefile and create labels as per PPP D119-796-141 chg 004  
290 - Packaging3-1 (Identify as per dwg & Stock Location: L6050)Identify and pack for shipping as per PPP D119-796-  
141  
300 - QC21 (QC21- Final Inspection - Work Order Release)  
on w/o 199490

Job BOM

| Part / Item     | Component Name           | Quantity      | Operation                 | Container |
|-----------------|--------------------------|---------------|---------------------------|-----------|
| D119-796-141TRN | Crosstube Turning Detail | 1 pcs (1 ea)  | 130-Crosstubes - Bend - 1 | 5179524   |
| CR3212-4-08     | Rivet                    | 16 Ea (16 ea) | 242-Crosstubes - 5 - B4B  |           |
| D2873-043       | Nut Plate Assembly       | 4 pcs (4 ea)  | 242-Crosstubes - 5 - B4B  |           |
| D5123-3         | Clamp Cushion            | 8 pcs (8 ea)  | 242-Crosstubes - 5 - B4B  |           |
| D5124-1         | Fwd Support              | 2 pcs (2 ea)  | 242-Crosstubes - 5 - B4B  |           |
| D5152-041       | Fwd Post Mount Assembly  | 2 pcs (2 ea)  | 242-Crosstubes - 5 - B4B  |           |
| D5305-1         | Shim                     | 2 pcs (2 ea)  | 242-Crosstubes - 5 - B4B  |           |
| MS21920-24      | Clamp                    | 4 Ea (4 ea)   | 242-Crosstubes - 5 - B4B  |           |
| MS21920-22      | Clamp                    | 4 Ea (4 ea)   | 242-Crosstubes - 5 - B4B  |           |

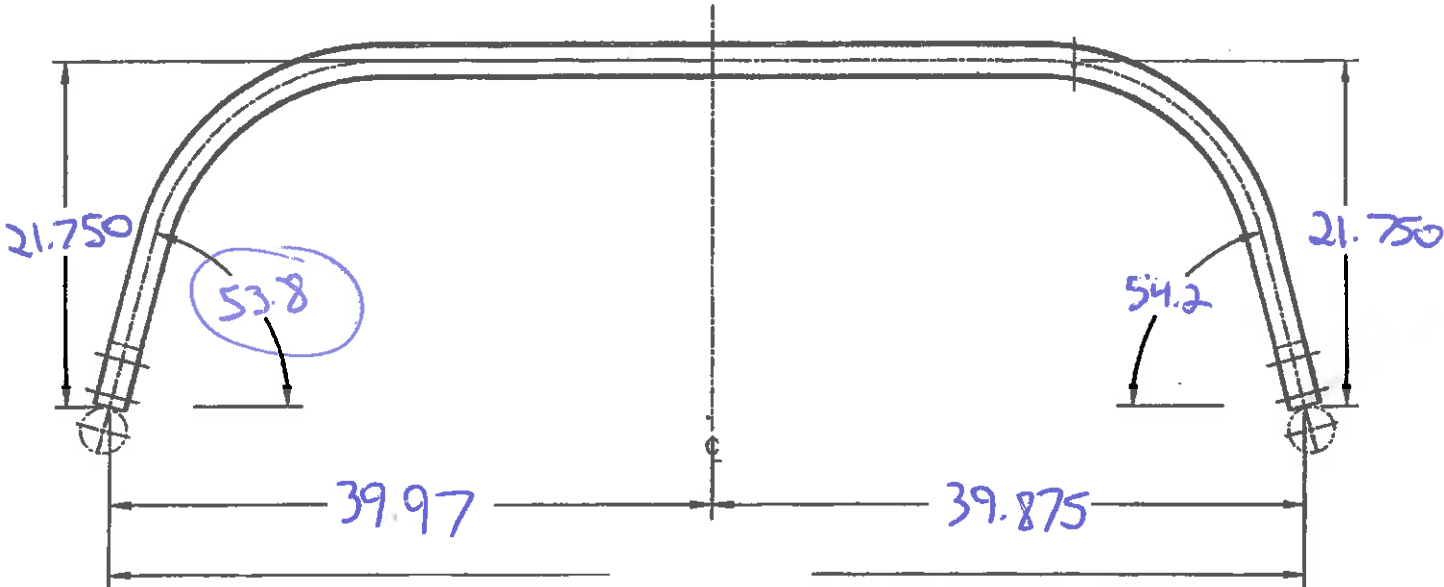
| Job Allocations           |                      |             |           |           |
|---------------------------|----------------------|-------------|-----------|-----------|
| Operation                 | Component Part       | Required    | Inventory | Allocated |
| 130-Crosstubes - Bend - 1 | D119-796-141TRN      | 1           | 3         | 0         |
| 242-Crosstubes - 5 - B4B  | CR3212-4-08          | 16 5173048  | 141       | 0         |
|                           | D2873-043            | 4 5186472   | 51        | 0         |
|                           | D5123-3 160079       | 8           | 175       | 0         |
|                           | D5124-1 5153825      | 2           | 8         | 0         |
|                           | D5152-041 5190362    | 2           | 10        | 0         |
|                           | D5305-1 5144003      | 2           | 10        | 0         |
|                           | MS21920-22 5171289   | 4           | 55        | 0         |
|                           | MS21920-24 5171290 ③ | 5 5065334 ③ | 25        | 0         |
| 252-Crosstubes            | D5149-041 5192135 ③  | 3           |           |           |

| Part Specifications |                                    |                                |                    |      |                  |
|---------------------|------------------------------------|--------------------------------|--------------------|------|------------------|
| Spec No             | Description                        | Target/Tolerance               | Limits             | Type | Special Comments |
| 1                   | Crosstube Assembly (AW119 MKI Fwd) | 6.000Inches ± 0.030            | 6.030<br>5.970     |      |                  |
| 2                   | Crosstube Assembly (AW119 MKI Fwd) | 2.516Inches ± 0.005            | 2.521<br>2.511     |      |                  |
| 3                   | Crosstube Assembly (AW119 MKI Fwd) | 2.333Inches + 0.005<br>- 0.000 | 2.338<br>2.333     |      |                  |
| 4                   | Crosstube Assembly (AW119 MKI Fwd) | 2.333Inches + 0.005<br>- 0.000 | 2.338<br>2.333     |      |                  |
| 5                   | Crosstube Assembly (AW119 MKI Fwd) | 2.408Inches + 0.005<br>- 0.000 | 2.413<br>2.408     |      |                  |
| 6                   | Crosstube Assembly (AW119 MKI Fwd) | 2.502Inches + 0.005<br>- 0.000 | 2.507<br>2.502     |      |                  |
| 7                   | Crosstube Assembly (AW119 MKI Fwd) | 2.596Inches + 0.005<br>- 0.000 | 2.601<br>2.596     |      |                  |
| 8                   | Crosstube Assembly (AW119 MKI Fwd) | 2.596Inches + 0.005<br>- 0.000 | 2.601<br>2.596     |      |                  |
| 9                   | Crosstube Assembly (AW119 MKI Fwd) | 6.000Inches ± 0.030            | 6.030<br>5.970     |      |                  |
| 10                  | Crosstube Assembly (AW119 MKI Fwd) | 2.516Inches ± 0.005            | 2.521<br>2.511     |      |                  |
| 11                  | Crosstube Assembly (AW119 MKI Fwd) | 2.333Inches + 0.005<br>- 0.000 | 2.338<br>2.333     |      |                  |
| 12                  | Crosstube Assembly (AW119 MKI Fwd) | 2.333Inches + 0.005<br>- 0.000 | 2.338<br>2.333     |      |                  |
| 13                  | Crosstube Assembly (AW119 MKI Fwd) | 2.408Inches + 0.005<br>- 0.000 | 2.413<br>2.408     |      |                  |
| 14                  | Crosstube Assembly (AW119 MKI Fwd) | 2.502Inches + 0.005<br>- 0.000 | 2.507<br>2.502     |      |                  |
| 15                  | Crosstube Assembly (AW119 MKI Fwd) | 2.596Inches + 0.005<br>- 0.000 | 2.601<br>2.596     |      |                  |
| 16                  | Crosstube Assembly (AW119 MKI Fwd) | 2.596Inches + 0.005<br>- 0.000 | 2.601<br>2.596     |      |                  |
| 17                  | Crosstube Assembly (AW119 MKI Fwd) | 102.260Inches ± 0.020          | 102.280<br>102.240 |      |                  |

Plex 4/25/19 1:20 PM Dart.lajeunesse.marie

|                                              |               |                                  |
|----------------------------------------------|---------------|----------------------------------|
| <b>DART AEROSPACE LTD</b>                    |               | <b>Work Order:</b> 194132        |
| <b>Description:</b> Crosstube Fwd, with Step |               | <b>Part Number:</b> D119-796-141 |
| <b>Inspection Dwg:</b> D119-796-141          | <b>Rev:</b> H | <b>Page 1 of 1</b>               |

| Required Dimension | Min    | Max    |
|--------------------|--------|--------|
| Height             | 21.490 | 21.750 |
| 1/2 Span           | 39.820 | 40.080 |
| Angle              | 54°    | 57°    |
| Total Span         | 79.640 | 80.160 |
| Bending Passes     | 8      | --     |
| Crushing           | --     | 6.8%   |



2. 199  
2. 456

|                | Side A | Side B |
|----------------|--------|--------|
| Bending Passes | 11     | 11     |
| Crushing       | 5.5%   | 5.3%   |
| Comments       |        |        |
|                |        |        |
|                |        |        |
|                |        |        |

2. 202  
2. 469

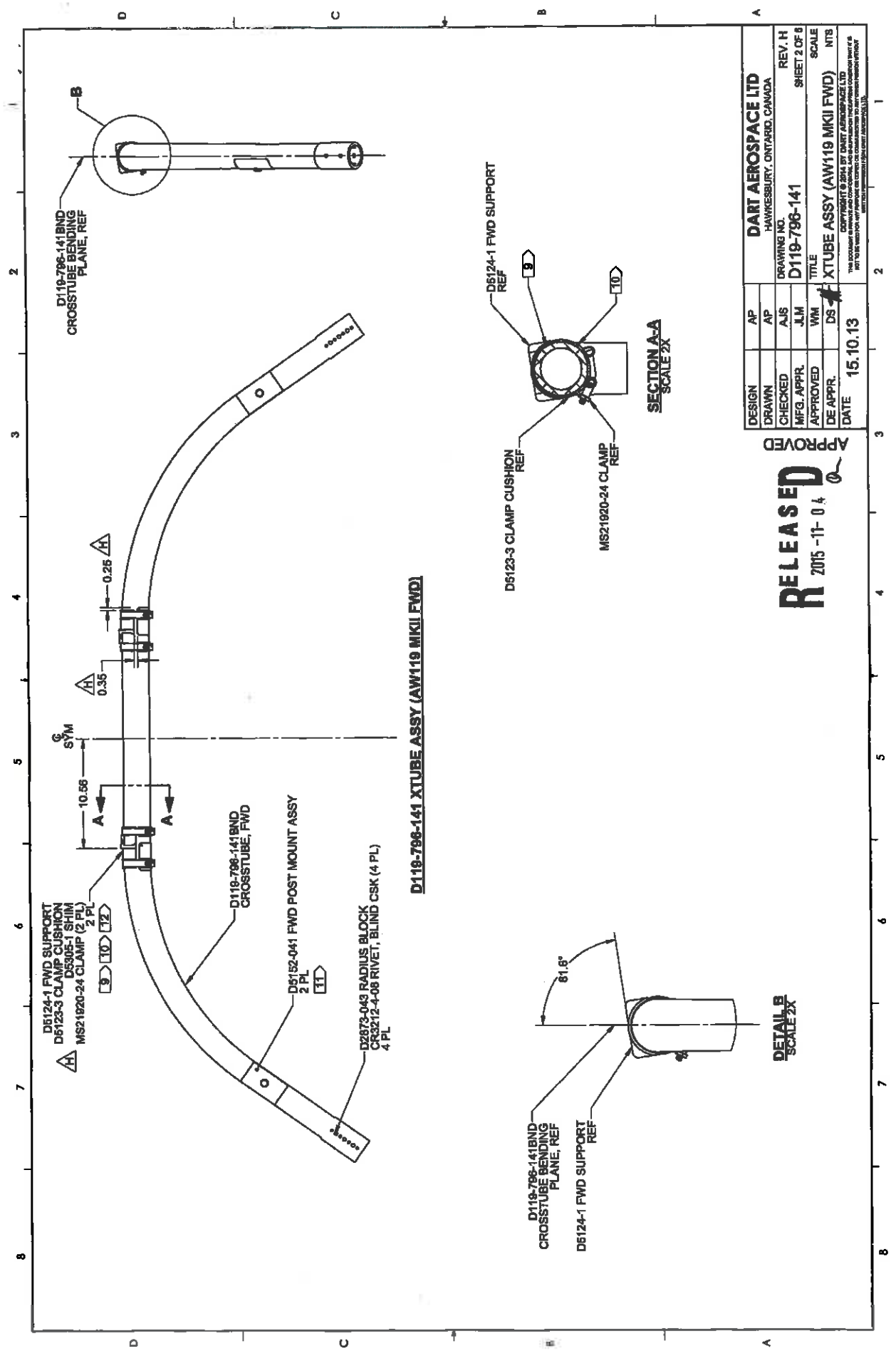
|                 |          |
|-----------------|----------|
| QC15 Inspection |          |
| Date            | 17-07-05 |

| Rev | Date     | Change          | Revised by | Approved |
|-----|----------|-----------------|------------|----------|
| A   | 15.04.14 | New Issue       | KJ         |          |
| B   | 15.11.12 | Dwg Rev updated | KJ         |          |
| C   | 16.01.15 | Dwg Rev updated | KJ         | up       |





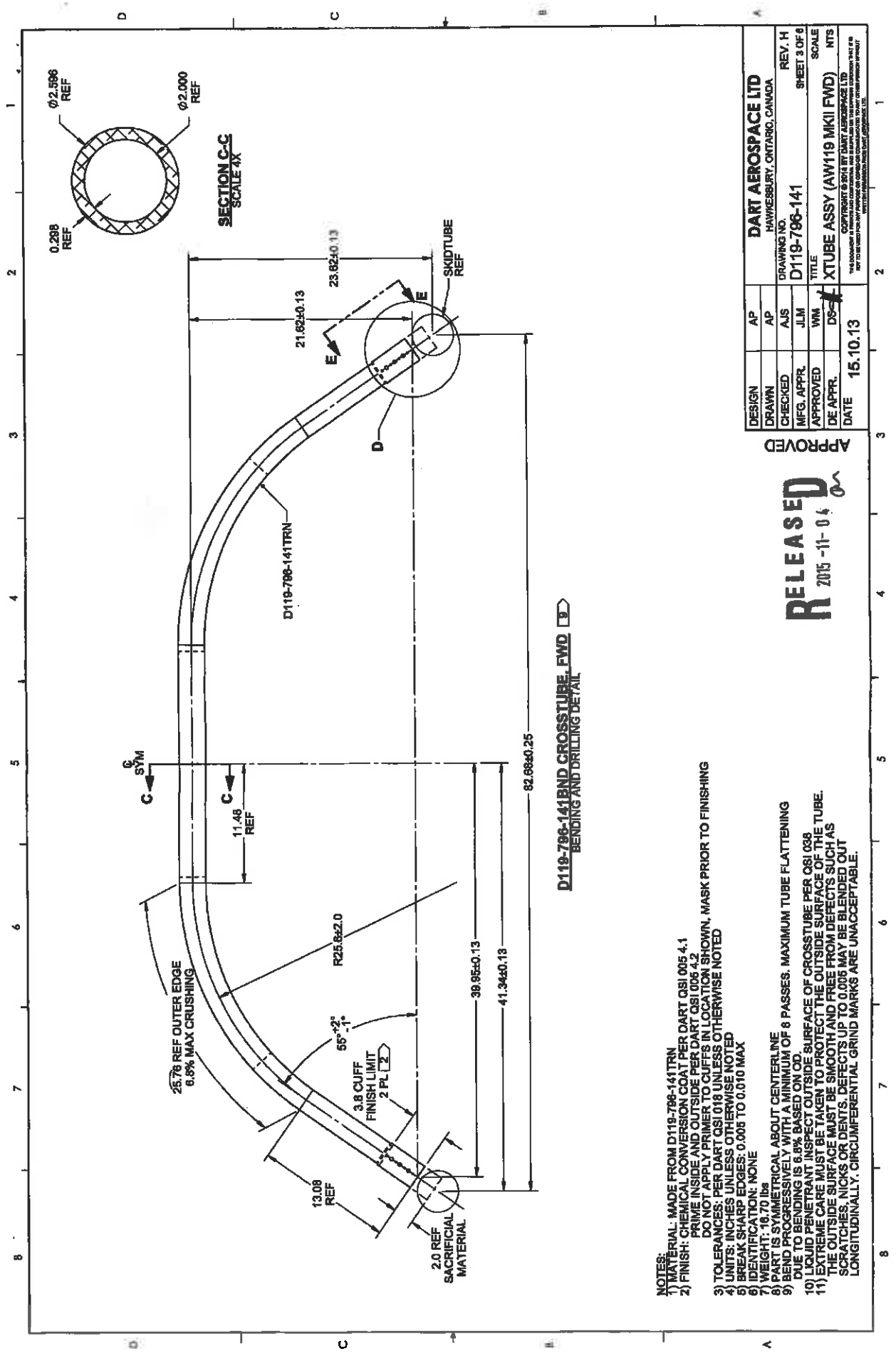




|            |          |          |                                      |
|------------|----------|----------|--------------------------------------|
| DESIGN     | AP       | AP       | DART AEROSPACE LTD                   |
| DRAWN      | AP       | AP       | HAWKESBURY, ONTARIO, CANADA          |
| CHECKED    | AJS      | AJS      | DRAWING NO. D119-798-141             |
| MFG. APPR. | JLM      | JLM      | REV. H SHEET 2 OF 8                  |
| APPROVED   | WM       | WM       | TITLE XTUBE ASSY (AW119 MKII FWD)    |
| DE APPR.   | DS       | DS       | SCALE NTB                            |
| DATE       | 15.10.13 | 15.10.13 | COMPONENT & 304L STEEL AEROSPACE LTD |

APPROVED

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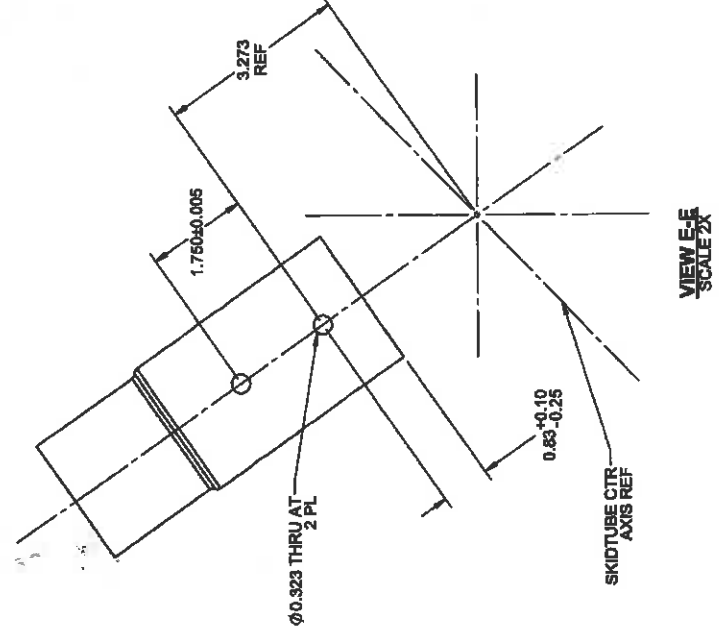
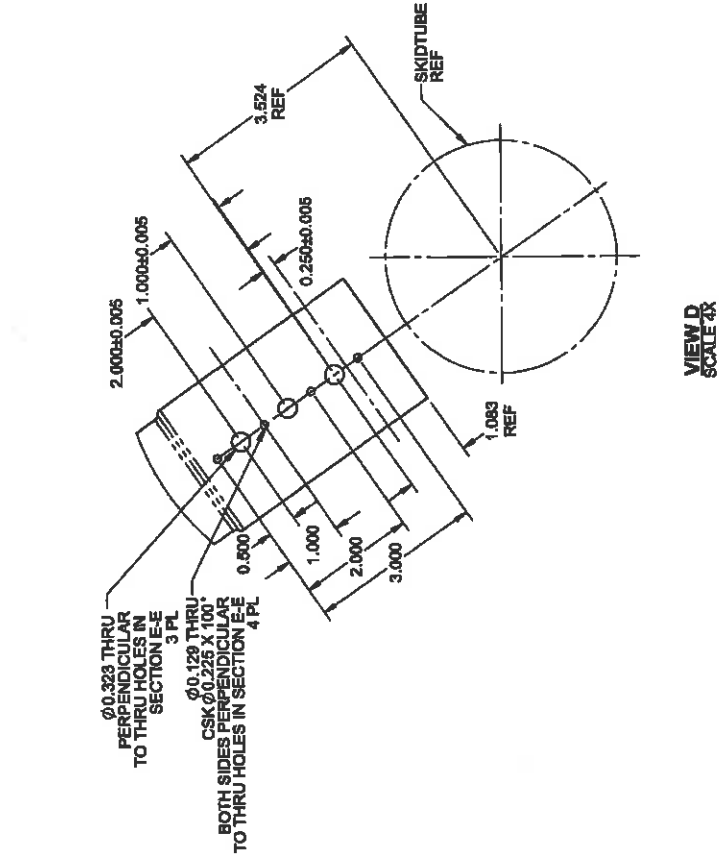


D119-786-141BND CROSS-TUBE FWD BENDING AND DRILLING DETAIL

NOTES:  
1) MATERIAL: MADE FROM D119-786-141 TRN  
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: NONE  
7) WEIGHT: 16.70 lbs  
8) PART IS SYMMETRICAL ABOUT CENTERLINE  
9) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6.8% BASED ON OD.  
10) LIQUID PENETRANT INSPECT FOR DEFECTS ON SURFACE OF CROSS-TUBE PER OSI 038  
11) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM DEFECTS SUCH AS SOOT, DIRT, RIPS OR DENTS. DEFECTS UP TO 0.005 MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

RELEASED  
R 2015-11-04

|            |          |          |                              |
|------------|----------|----------|------------------------------|
| DESIGN     | AP       | AP       | DART AEROSPACE LTD           |
| DRAWN      | AP       | AP       | HAWTHESBURY, ONTARIO, CANADA |
| CHECKED    | AJS      | JLM      | D119-786-141                 |
| MFG. APPR. | WM       | WM       | XTUBE ASSY (AW119 MKII FWD)  |
| DE APPR.   | DS       | DS       | SCALE                        |
| DATE       | 15.10.13 | 15.10.13 | NTS                          |

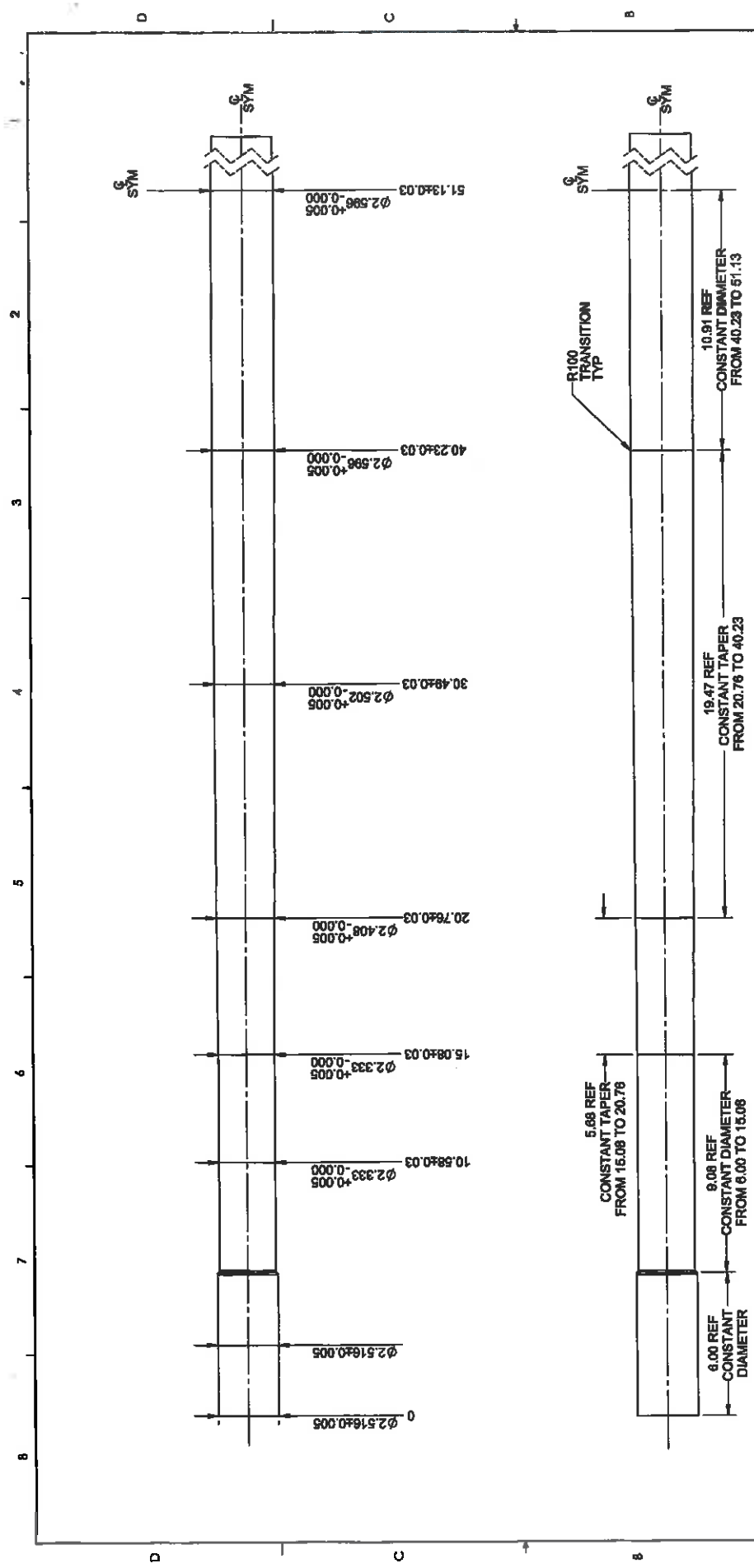


RELEASED  
R 2015-11-04

APPROVED

|            |          |          |                             |
|------------|----------|----------|-----------------------------|
| DESIGN     | AP       | AP       | DART AEROSPACE LTD          |
| DRAWN      | AP       | AP       | HAWKESBURY, ONTARIO, CANADA |
| CHECKED    | AJS      | AJS      | DRAWING NO. D119-796-141    |
| MFG. APPR. | JLM      | JLM      | REV. H SHEET 4 OF 8         |
| APPROVED   | WM       | WM       | TITLE                       |
| DE APPR.   | DS       | DS       | XTUBE ASSY (AW119 MKI FWD)  |
| DATE       | 15.10.13 | 15.10.13 | SCALE NTS                   |

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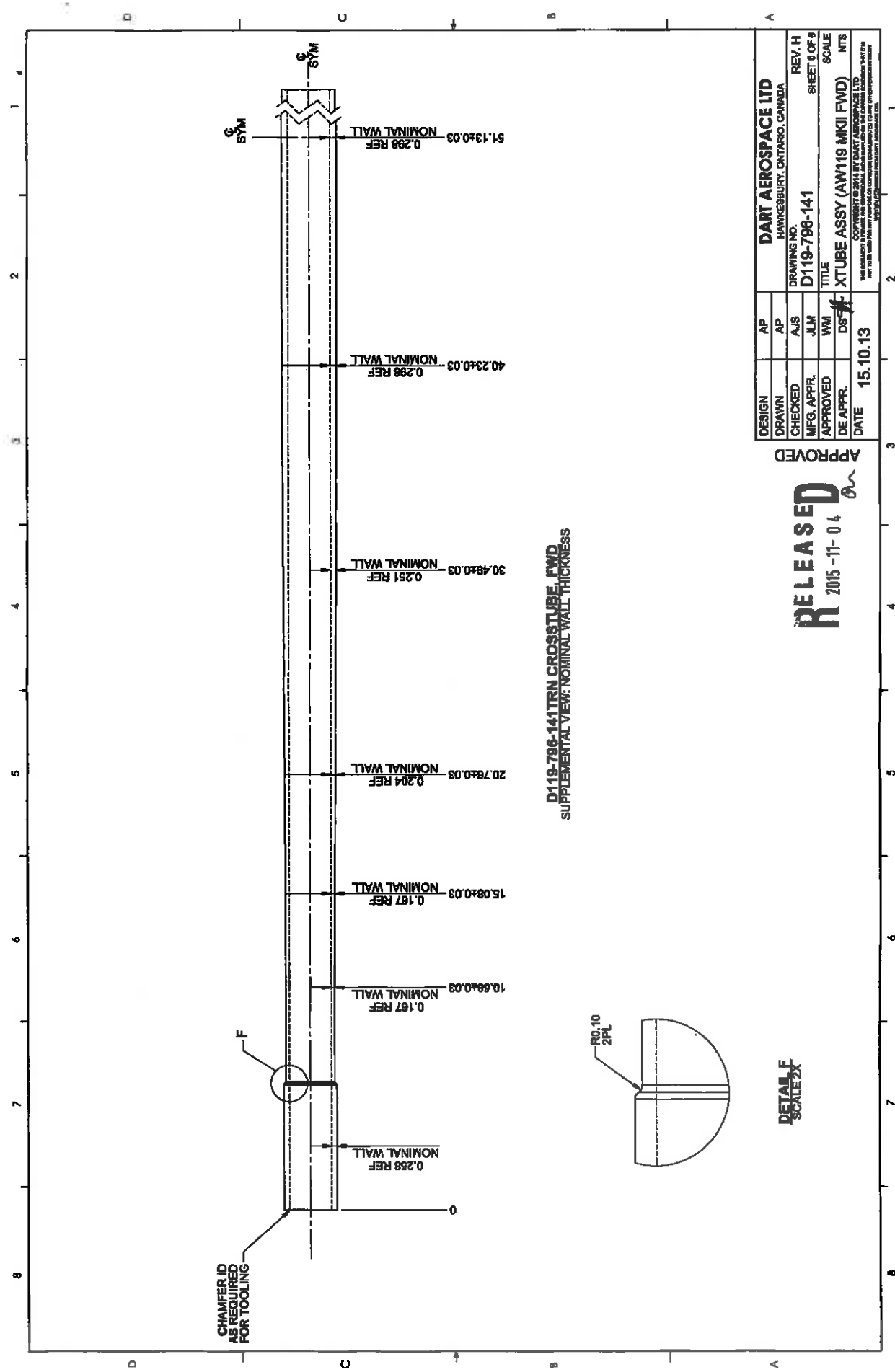


D119-796-141 TRN CROSSTUBE, FWD

- NOTES:
- 1) MATERIAL: MANUFACTURE FROM D8024-103 (PREFERRED) OR D8005-103
  - 2) FINISH: NONE, PER DART Q31.016 (PREFERRED) OR D8005-103
  - 3) TOLERANCES: PER DART Q31.016 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.003 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 16.70 lbs
  - 8) PART IS SYMMETRICAL ABOUT CENTERLINE

RELEASED  
2015-11-04

|            |          |              |                             |
|------------|----------|--------------|-----------------------------|
| DESIGN     | AP       | AP           | DART AEROSPACE LTD          |
| DRAWN      | AP       | AP           | HAWKESBURY, ONTARIO, CANADA |
| CHECKED    | AJS      | REV. H       |                             |
| MFG. APPR. | JLM      | D119-796-141 | SHEET 5 OF 8                |
| APPROVED   | WM       | TITLE        | XTUBE ASSY (AW119 MKII FWD) |
| DE APPR.   | DS       | SCALE        | NTS                         |
| DATE       | 15.10.13 |              |                             |



DETAIL F  
SCALE 2X

RELEASED  
2015-11-04

APPROVED

|            |          |     |                                                                                                |
|------------|----------|-----|------------------------------------------------------------------------------------------------|
| DESIGN     | AP       | AP  | DART AEROSPACE LTD                                                                             |
| DRAWN      | AP       | AP  | HAWKESBURY, ONTARIO, CANADA                                                                    |
| CHECKED    | AJS      | JLM | DRAWING NO. D119-798-141                                                                       |
| MFG. APPR. | JLM      | JLM | REV. H SHEET 8 OF 8                                                                            |
| APPROVED   | WM       | WM  | TITLE XTUBE ASSY (AW119 MKII FWD)                                                              |
| DE APPR.   | DS       | DS  | SCALE NTS                                                                                      |
| DATE       | 15.10.13 |     | NOT TO BE USED FOR ANY PURPOSE OR CONCEPTS UNLESS SPECIFICALLY APPROVED BY DART AEROSPACE LTD. |

Entered: \_\_\_\_\_ Date: \_\_\_\_\_

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



Route update only

NCR No.

|                                                                                                                                                                                                                                                                                                                                                                              |             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |  |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|
| Job: _____<br>Part No. _____                                                                                                                                                                                                                                                                                                                                                 |             | DISPOSITION<br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input checked="" type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |  | DEPARTMENT/PROCESS<br>Skid-tube <input type="checkbox"/><br>Machining <input type="checkbox"/><br>Large Fab <input type="checkbox"/><br>Cross tube <input type="checkbox"/><br>Small Fab <input type="checkbox"/><br>Finishing <input type="checkbox"/><br>Eng. (Non-AW) <input type="checkbox"/><br>Prod. Eng. Coord. <input type="checkbox"/><br>Rec/Store/Packaging <input type="checkbox"/><br>Engineering <input type="checkbox"/><br>Water Jet <input type="checkbox"/><br>Supplier <input type="checkbox"/><br>Quality <input type="checkbox"/> |  |
| Date :                                                                                                                                                                                                                                                                                                                                                                       | Sequence #: | QTY Affected :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  | MRB (QS042)<br>INSP 12 4/14/76<br>Completed By 4/14/76                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |  |
| Description Work Order Deviation<br><br>One angle is 53.8°                                                                                                                                                                                                                                                                                                                   |             | Disposition<br><br>Acceptable                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |  | Lead hand / Supervisor<br><br>QC / QA Coordinator                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |  |
| Root Cause<br>Operator <input type="checkbox"/><br>Manufacturing Process <input type="checkbox"/><br>Equip/Tooling <input type="checkbox"/><br>Handling/Preservation <input type="checkbox"/><br>Material <input type="checkbox"/><br>Product Improvement <input type="checkbox"/><br>Process Improvement <input type="checkbox"/><br>Human Factors <input type="checkbox"/> |             | FAULT CATEGORY<br>Pressure/Forced <input type="checkbox"/><br>Bending <input type="checkbox"/><br>Crushing <input type="checkbox"/><br>Cracks <input type="checkbox"/><br>Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/><br>Marks/Chatter <input type="checkbox"/><br>Mislabeled <input type="checkbox"/><br>Other/Details: _____<br>Contamination <input type="checkbox"/><br>Misaligned/off center <input type="checkbox"/><br>BOM/Route <input type="checkbox"/><br>Broken/Damage/Defect <input type="checkbox"/><br>Incomplete/Unclear Instructions <input type="checkbox"/><br>Drill Holes <input type="checkbox"/><br>Fit/Function <input type="checkbox"/><br>Power Loss/Surge <input type="checkbox"/><br>Folio/Program <input type="checkbox"/><br>Grain Direction <input type="checkbox"/><br>Weld <input type="checkbox"/><br>Wrong Stock Pulled <input type="checkbox"/><br>Out of Sequence <input type="checkbox"/><br>Off-set/Set-up <input type="checkbox"/><br>Positioned Wrong <input type="checkbox"/><br>Outside Tolerance <input type="checkbox"/><br>Drawing <input type="checkbox"/><br>Finish <input type="checkbox"/><br>Part Lost/Missing <input type="checkbox"/><br>Misread <input type="checkbox"/> |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |  |



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada  
  
Tel (613) 632-5200

**PURCHASE ORDER**  
**POHB044190**



|                                                                                                                                                   |                                                                                                                                                                                                                                                |
|---------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>Supplier:</b> SKY002-VC<br>Skyservice<br>6120 Midfield Road<br>Mississauga<br>ON<br>L5P 1B1 Canada<br>Phone: 905-678-5636<br>Fax: 905-678-5841 | <b>PO No:</b> POHB044190<br><b>PO Date:</b> 8/1/19<br><b>Due Date:</b> 8/2/19<br><b>Purchase Order Revision:</b><br><b>Revision Date:</b><br><b>Ship-To Contact:</b> Guerin, Kimberley<br>Phone: 613-632-5200 Ext: 298<br>kguerin@dartaero.com |
| <b>Attention:</b> Jenne, Heather                                                                                                                  | <b>Via:</b> Ground<br><b>Pymt Terms:</b> Net 30<br><b>Freight Terms:</b><br><b>Special Comments:</b>                                                                                                                                           |
| <b>Ship To:</b> 1270 Aberdeen Street<br>Hawkesbury<br>ON<br>K6A 1K7 Canada<br>Phone: 613-632-5200                                                 |                                                                                                                                                                                                                                                |

| Items     |        |               |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |        |         |          |                |                   |         |                  |                |
|-----------|--------|---------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------|---------|----------|----------------|-------------------|---------|------------------|----------------|
| Line Item | Job    | Part          | Description                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | Status | Account | Due Date | Order Quantity | Received Quantity | Balance | Unit Price (CAD) | Extended Price |
| 1         | 198181 | D130-1048-141 | EC130 Fwd Crosstube<br>: TC STC SH19-4 Issue 1<br>(Outsource process - NDT per QSI038 4.1)<br>*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***<br>ISSUE<br>P/O: _____<br>Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order NDT C OF C IS REQUIRED                                                                                                                                                                                                                                                                                                 | Firmed | -       | 8/2/19   | 1 pcs          | 0 pcs             | 1 pcs   | \$169.00/pcs     | \$169.00       |
| 2         | 194132 | D119-796-141  | Fwd Crosstube Installation Without Step (No Hardware)<br>: TC STC SH14-45-Issue 1, FAA STC SR03504NY 15/01/28, EASA STC 10052022 Revision 1 15/02/13, DGCA INDIA LoA 07-09/2011-AED (Part) 15/07/16, BRAZIL STC 2015S07-16 15/07/30, CAAP PHILIPPINES LoA 16/05/11, CHINA VSTC0757 16/07/22, RUSSIA STC CT316-A119 16/08/11, DGAC INDONESIA STC SR025 18/02/19<br>Outsource2 (Outsource process - NDT per QSI038 4.1)<br>*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue<br>P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order | Firmed | -       | 8/2/19   | 1 pcs          | 0 pcs             | 1 pcs   | \$169.00/pcs     | \$169.00       |

DAS  
40  
8-89





Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada  
  
Tel (613) 632-5200

**PURCHASE ORDER**  
**POHB044190**



| Items      |     |      |                  |         |         |          |                |                   |         |                  |                |
|------------|-----|------|------------------|---------|---------|----------|----------------|-------------------|---------|------------------|----------------|
| Line Item  | Job | Part | Description      | Status  | Account | Due Date | Order Quantity | Received Quantity | Balance | Unit Price (CAD) | Extended Price |
| 194133     |     |      | 1 X AUG 0 2 2019 | Ordered | -       | 8/2/19   | 1 pcs          | 0 pcs             | 1 pcs   | \$169.00/pcs     | \$169.00       |
| 194134     |     |      | 1 X AUG 0 2 2019 | Ordered | -       | 8/2/19   | 1 pcs          | 0 pcs             | 1 pcs   | \$169.00/pcs     | \$169.00       |
| 194135     |     |      | 1 X AUG 0 2 2019 | Ordered | -       | 8/2/19   | 1 pcs          | 0 pcs             | 1 pcs   | \$169.00/pcs     | \$169.00       |
| Sub Total: |     |      |                  |         |         |          | 4              | 0                 | 4       |                  | \$676.00       |

Grand Total: \$845.00

Order Notes

- Procurement Quality Clauses  
A005 right of entry  
A012 chemical and physical test report  
A016 personnel qualification  
A017 raw material identification (as applicable)  
  
A022 Apical Processing  
A024 process certifications  
A026 certification of material conformance  
  
A041 quality management system  
A042 dart notification by supplier  
A043 retention of quality documents  
  
A048 counterfeit parts avoidance, detection, mitigation and disposition program  
  
A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit [www.dartaerospace.com](http://www.dartaerospace.com) for further explanation.

Plex 8/2/19 8:57 AM Dart.Guerin.Kimberley



**Work Order Traveler**  
Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCOA AMO 53-89 / EASA 145.7142 / BDA AMO 385

|                |                               |               |                       |
|----------------|-------------------------------|---------------|-----------------------|
| WO #: MW041275 | Customer: Dart Aerospace Ltd. | Dept: NDT YUL | Reference: POHB044190 |
| Descr: "       | PN:                           | S/N:          | Qty: 1                |
| Make:          | Model:                        | Reg:          | A/C S/N:              |
| TSN:           | CSN:                          | TSO:          |                       |

|                   |             |
|-------------------|-------------|
| Task: UNSCHEDULED | Sequence: 1 |
|-------------------|-------------|

Work Required:

CARRY OUT NDT INSPECTION (LIQUID PENETRANT) ON 5 CROSSTUBES

ITEM ID: D119-796-141 FWD CROSSTUBE INST. WTHOUT STEPS.

- 1 - WORK ORDER ID#: 194132
- 2 - WORK ORDER ID#: 194133
- 3 - WORK ORDER ID#: 194134
- 4 - WORK ORDER ID#: 194135

193

ITEM ID: D130-1048-141 EC130 FWD CROSSTUBE.

- 5 - WORK ORDER ID#: 198181

|                                                                                               |  |  |  |  |  |            |                                                                                      |
|-----------------------------------------------------------------------------------------------|--|--|--|--|--|------------|--------------------------------------------------------------------------------------|
| Action Taken:                                                                                 |  |  |  |  |  | Date:      | Initial/Stamp:                                                                       |
| LIQUID PENETRANT INSPECTION CARRIED OUT ON ITEMS LISTED ABOVE (ITEMS 1-5) AS PER ASTM1417M-16 |  |  |  |  |  | 2 Aug 2019 |  |
| NO CRACK FOUND                                                                                |  |  |  |  |  |            |                                                                                      |
| PEN ZL-37, MPO23206, CLEANER SKC-S MPO15030, EMU. MPO15896, DEV. MPO23451, UV LIGHT M-20142   |  |  |  |  |  |            |                                                                                      |

| Description | Location | P/N | Qty | Batch | S/N Off | S/N On |
|-------------|----------|-----|-----|-------|---------|--------|
|             |          |     |     |       |         |        |
|             |          |     |     |       |         |        |
|             |          |     |     |       |         |        |
|             |          |     |     |       |         |        |
|             |          |     |     |       |         |        |
|             |          |     |     |       |         |        |
|             |          |     |     |       |         |        |

RECEIVED

AUG 02 2019

DART AEROSPACE LTD.

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

|                          |                                                                                     |                                                                                       |            |
|--------------------------|-------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------|------------|
| Signature:               |  | ACA/SCA Stamp                                                                         | Date:      |
| Name: ANTONINO MARCHETTA |                                                                                     |  | 2 Aug 2019 |

## Change Record

PAGE 1 OF 1

**Part Number:** D119-796-141

**Description:** CROSSTUBE INSTALLATION, FWD STD, W/O PEG STEPS

[illegible]